

Work Order ID 162860

Friday, June 16, 2017 8:11:26 AM

162860

Page 1

Item ID: D5136-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Contact Pad, LH

Start Date: 7/3/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/13/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: JUN 16 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5136	A

100

0.00

100

Doosan

Memo

2.21

Doosan Lathe

Machine as per folio FB334 turning detail.

-Deburr.

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.06

Quality Control

6 _____ SL17-6-22

6 _____ SL17-6-22

[Signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		1.55							DAS 45 9-89 2017-7-6
120 HAAS 1 HAAS CNC vertical machine #1	Memo Machine as per Folio FB334 Folio Rev: <u>AA</u> Dwg Rev: <u>A</u> 1-Deburr 2- Engrave P/N as per dwg.	1.28				<u>6</u>	<u>0</u>		
130	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 45 9-89 2017-7-6
130 QC Quality Control	Memo	0.06				<u>6</u>	<u>0</u>		
140	QC8- Inspect parts - second check	0.00							DAS 44 9-89 2017-07-0
140 QC Quality Control	Memo	0.12				<u>6</u>	<u>0</u>		

DQA: _____ Date: _____



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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Packaging

Memo

LOCATION : LG055

0.06

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Quality Control

Memo

0.60

b
DAS
6 JUL 10 2017
9-89

17/7/13 J

N

JUL 11 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Friday, June 16, 2017 8:11:25 AM

Page 1

Work Order ID: 162860

162860

Parent Item: D5136-1

D5136-1

Parent Item Name: Contact Pad, LH

Start Date: 7/3/2017

Required Date: 7/13/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A RQ verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-005		Manufactured	No			100	Each	22.0000	0.33331	1.99986			
D6104-005									**				
Round Billet, 17-4													

17-6-22

Location

Loc Qty

Loc Code

MAT043

22

155445

1

156738

7

160147

4

162155

10

1

DQA: _____ Date: _____

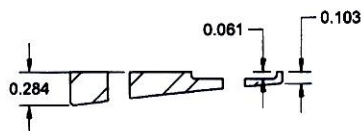
WORK ORDER NON-CONFORMANCE / UPDATE



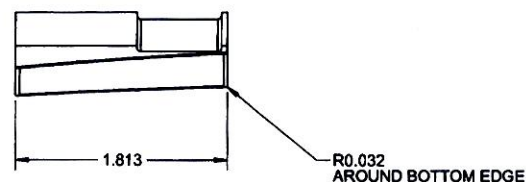
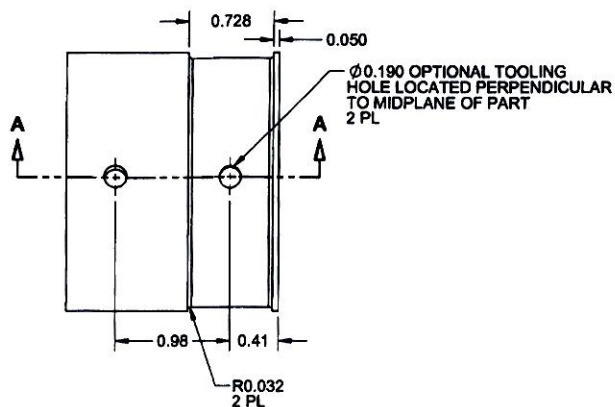
QA Closed: _____ Date: _____

Work Order update only ☐

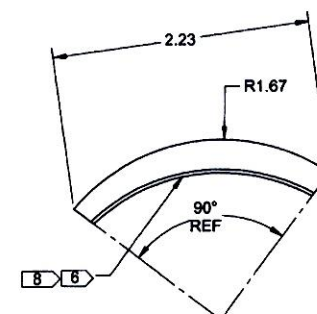
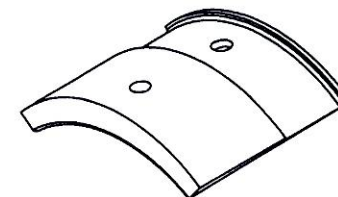
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SECTION A-A
SCALE 1X



D5136-1 CONTACT PAD, LH



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 162860 HLG
120616

NOTES:

- 1) MATERIAL: 17-4PH PER AMS 5604/5643
PER DART SPEC M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.4 IN LOCATION SHOWN (PART NUMBER ONLY)
IDENTIFY BATCH NUMBER PER QSI METHOD 6.7
- 7) WEIGHT: 0.18 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5136-1-REVA.SLDPRT"

RELEASED
2014-08-25

PAGE	NEW ISSUE	AP	14.07.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5136	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	CONTACT PAD	NTS
DATE	14.07.29	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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